

Date: Tuesday, 4/17/2007 3:56:45 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT WEB
Job Number : 31930	
Estimate Number : 10791	
P.O. Number : <i>N/A</i>	Part Number : D3282041
This Issue : 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3282 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : C
Previous Run : 30782	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/24/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>8</i> Um: Each
Comment : Est Rev: B 05.09.23 Procedure change KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2792-130

Extrusion

*B24030**Pm 07-04-26 (8)*

Identify as D3282-1

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

*Pm 07-04-26 (1)*

Cut to length as per Dwg D3282.

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 &amp; Dwg D3282

2-Deburr

*7ml 07/05/14*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*7ml 07/05/14*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SA 07.05.15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 703530PAR #: see PAR 179Fault Category: Prod/EngineeringNCR: Yes NoDQA: QDate: 07/07/12

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-05-15	3.0	-8 parts with 1 hole missing. Step missing from machine folio, program.		① Drill hole manually when installing the chabler. ② Verify hole before riveting the chabler, by Q.C.	and 07/05/23	07-05-23	05/04/12	07-05-15
07-05-15	3.0	"		③ Adjust folio to add hole onto the machining program PAR 179 ④ Verify by Q.C.		07-05-15	05/04/12	07-05-15

NOTE: Date &amp; initial all entries

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Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7-6-6

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7-6-6

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

13 31942 (2)  
13 32477 (14)

7-6-6

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 228.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

1100854 (57)

7-6-6

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web  
A/RN/ALPS-3 1103674

See Pro  
At sequence  
3.0

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-6-27 (1)

En 07/06/29

only 7 are installed in  
17 SKID tube

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

DP 7-6-27 (1)  
4/6 in SKID tube cell En 07/06/29 (17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:45 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 31930

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



7

Comment: FINAL INSPECTION/W/O RELEASE

07/07/12

Job Completion



cl 07-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	31930
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.570	✓			
1.500	+/-0.010	1.500	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	5.999	✓			
1.250	+/-0.010	1.250	✓			
30.000	+/-0.010	30.000	✓			
1.500	+/-0.010	1.500	✓			
72.01	+/-0.030	72.010	✓			
61.75	+/-0.030	61.750	✓			
57.50	+/-0.030	57.500	✓			
49.19	+/-0.030	49.190	✓			
43.94	+/-0.030	43.940	✓			
39.69	+/-0.030	39.690	✓			
26.68	+/-0.030	26.68	✓			
0.55	+/-0.030	0.498	✓			
1.970	+/-0.010	1.970	✓			
2.38	+/-0.030	2.380	✓			
0.05	+/-0.030	0.045	✓			

Measured by: <i>JML</i>	Audited by: <i>SD</i>	Prototype Approval:	N/A
Date: 07/05/12	Date: 07.05.15	Date:	N/A

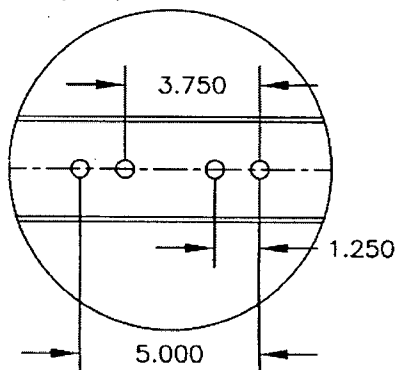
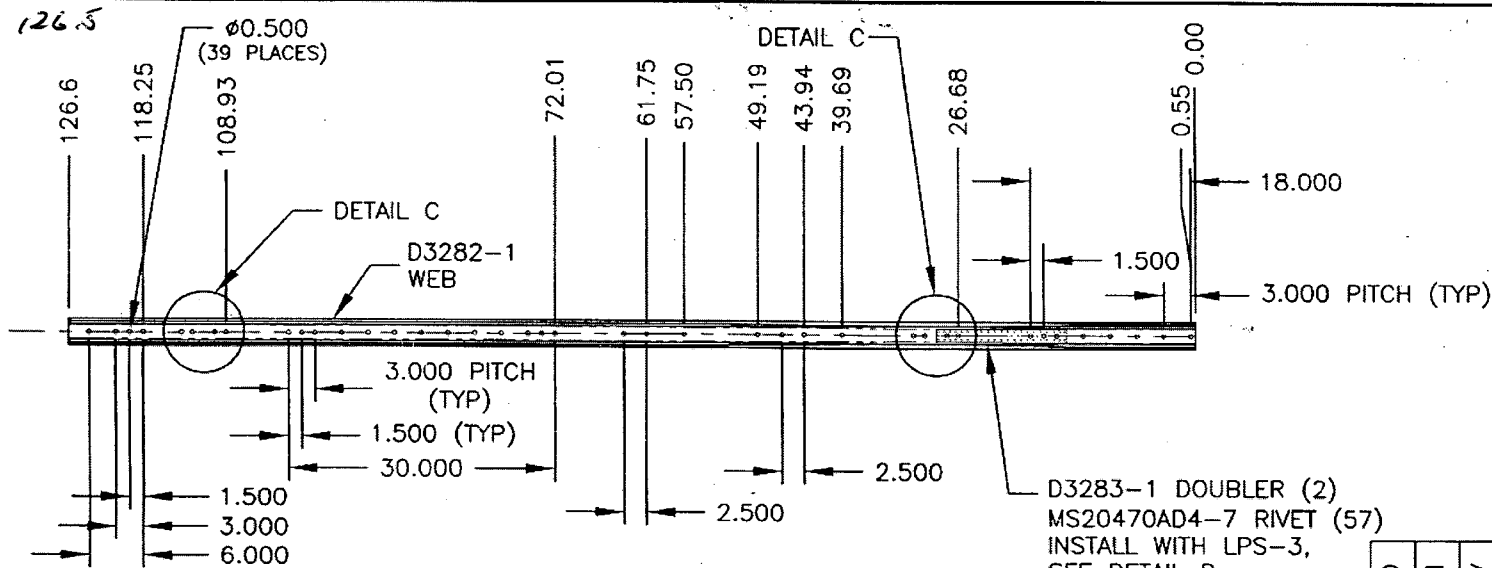
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



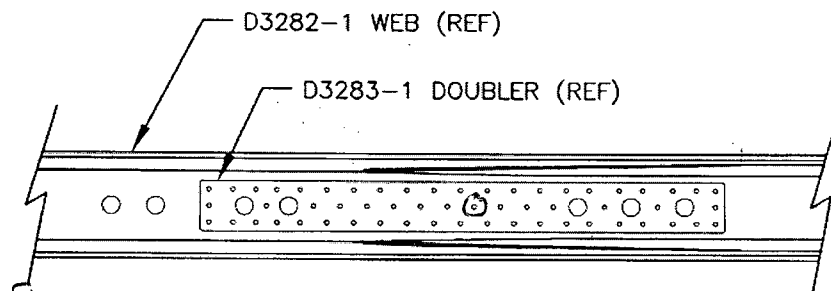


**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
				SHEET 1 OF 2
				SCALE
A	04.05.05	NEW ISSUE		
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS		
C	05.08.09	REMOVE D3390-1, NOW MACHINED		



**DETAIL C**  
SCALE 1:5  
RIVET HOLES NOT SHOWN  
FOR CLARITY



**DETAIL D**  
SCALE 1:5

RELEASED  
05.09.12

**D3282-041 FLOAT WEB**

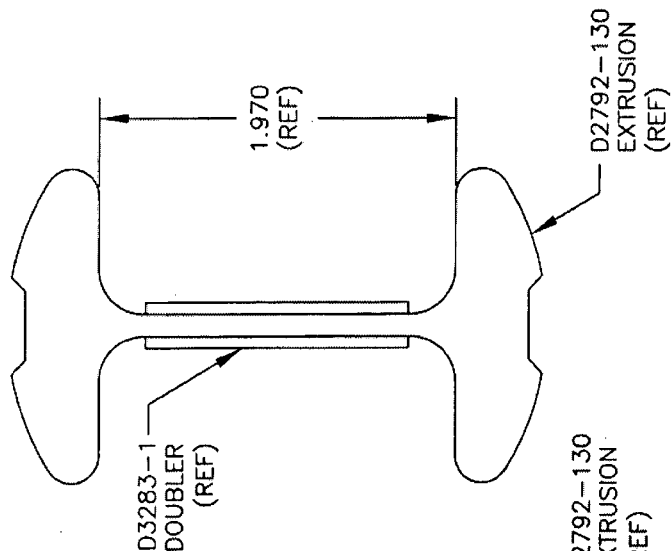
- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

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WITHOUT NOTICE

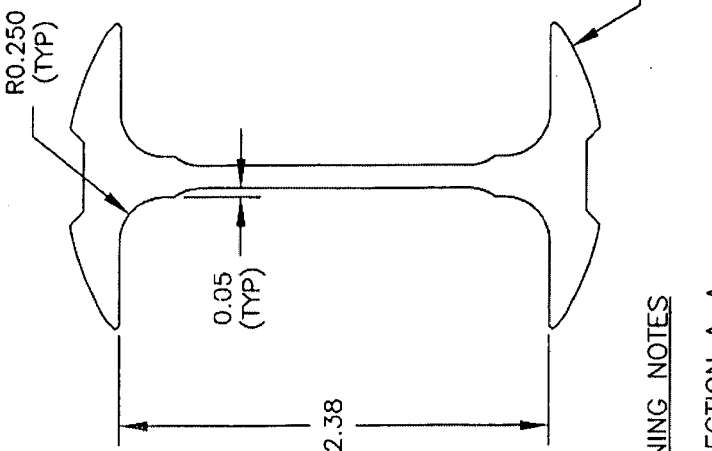


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	FLOAT WEB, 206L/407	SHEET 2 OF 2
				SCALE
				1:20

## SECTION B-B



## SECTION A-A



### D3282-1 MACHINING NOTES

1 UNIFORM SECTION A-A

2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B

3 UNIFORM SECTION B-B

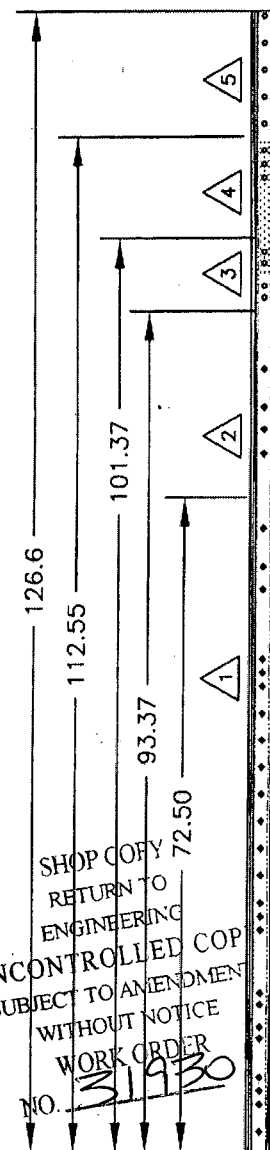
4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A  
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,  
SEE DETAIL D FOR REFERENCE

5 UNIFORM SECTION A-A

6 R1.00 BETWEEN SECTIONS

RELEASED

05.09.12 *[Signature]*



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